

FIG. 1

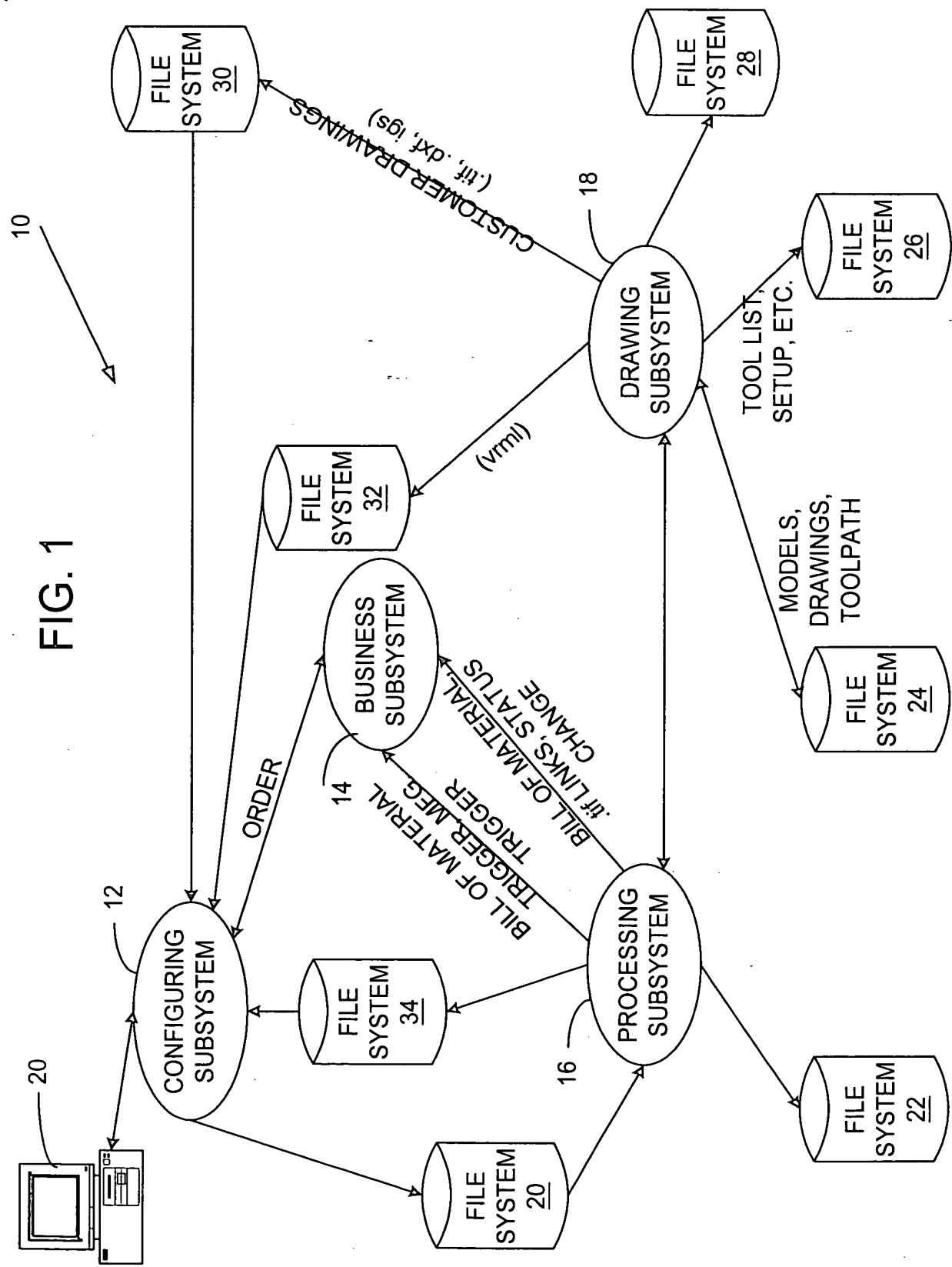
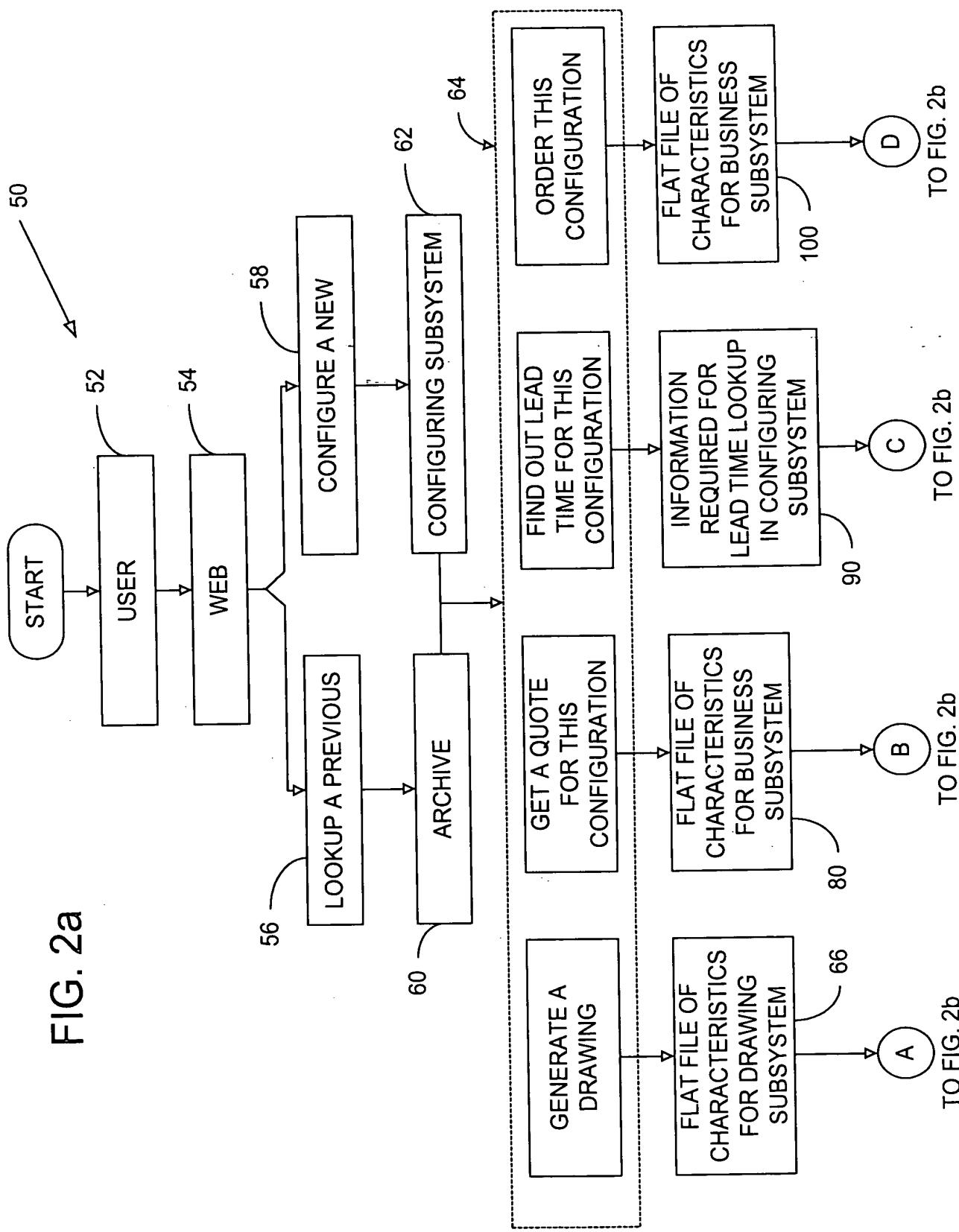


FIG. 2a



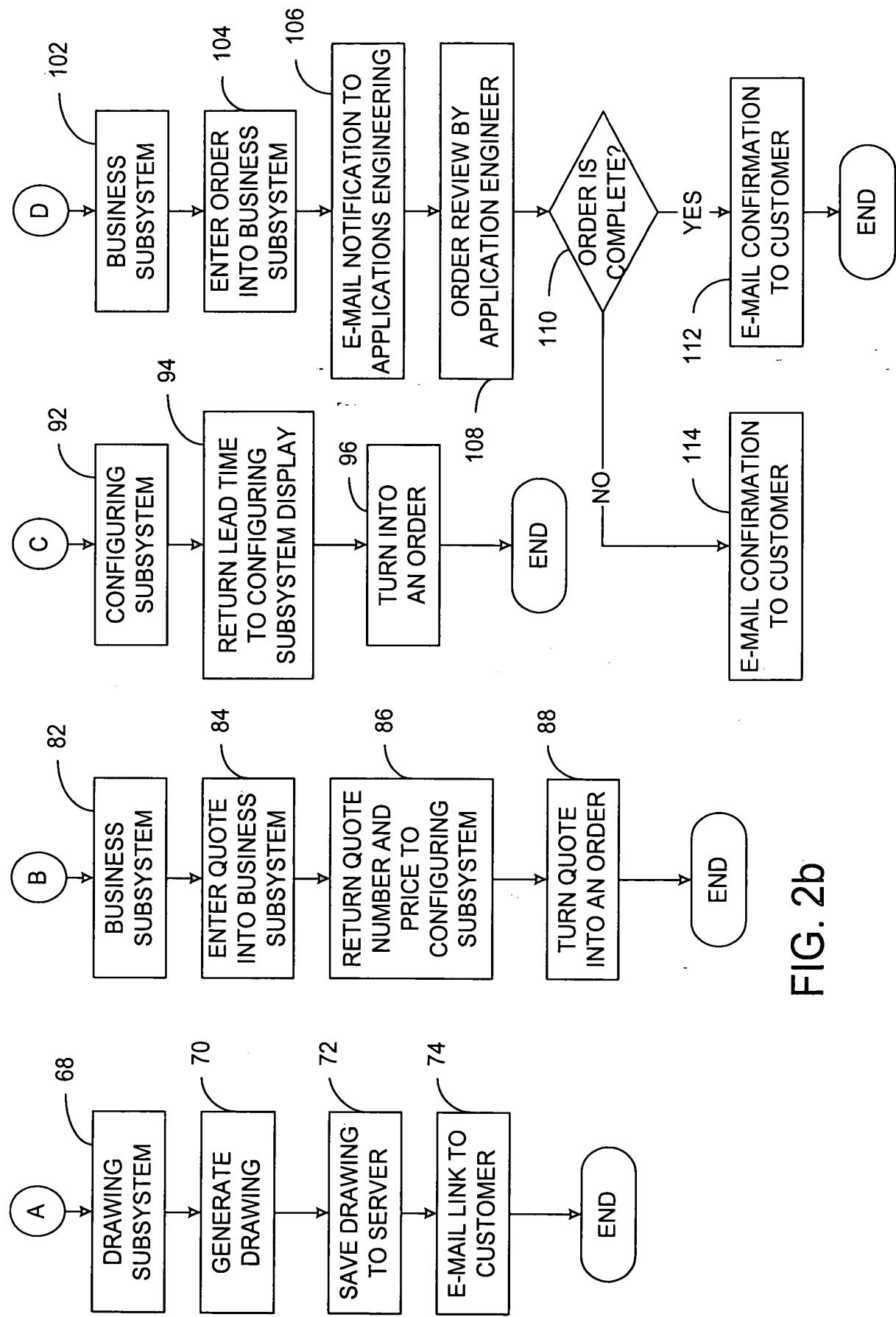


FIG. 2b

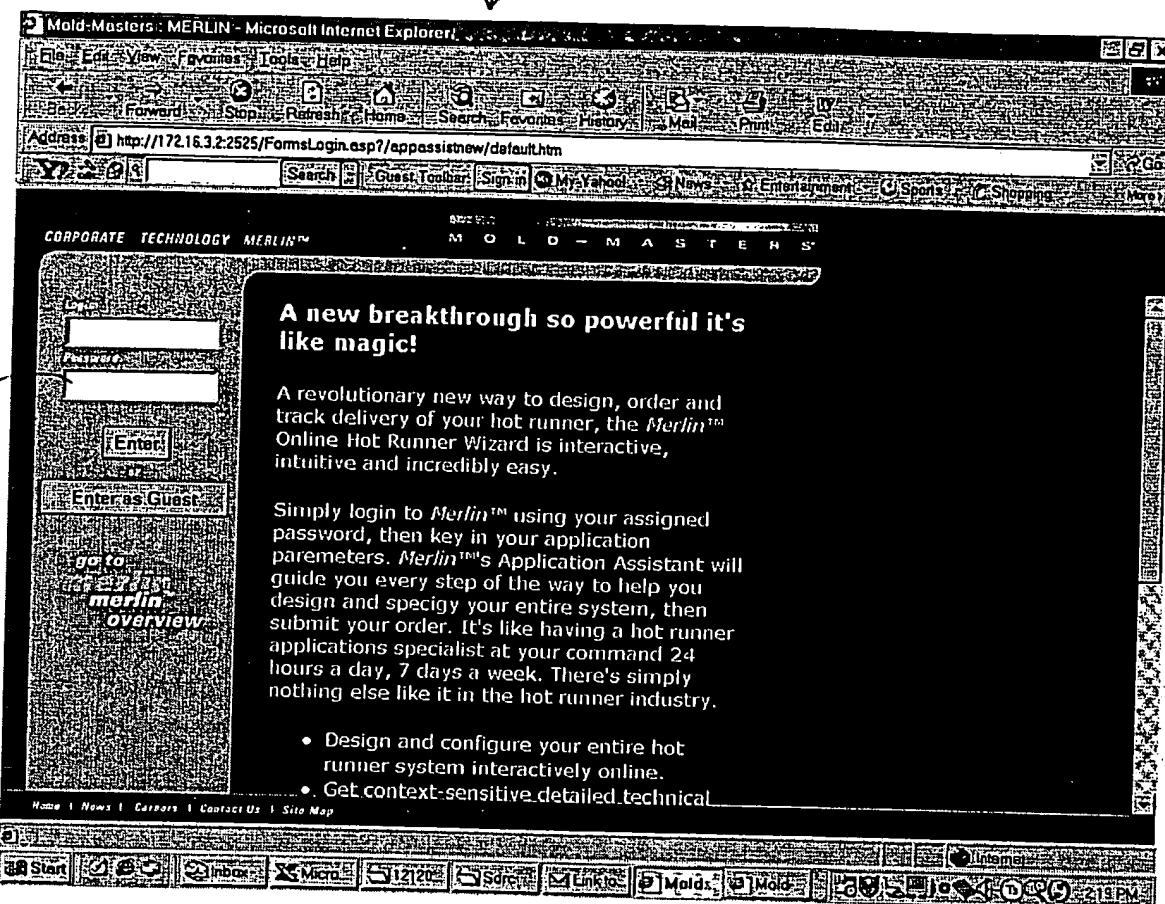


FIG. 3

3 110

112

114

116

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Mold-Masters Online Design Guide - Microsoft Internet Explorer

File Edit View Favorites Tools Help

Back Forward Stop Refresh Home Search Favorites History Mail Print Edit

Address: http://172.16.3.2:2525/default.htm

Search Guest Toolbar Sign-in My Yahoo! News Entertainment Sports Shopping More

Merlin Catalog Home MOLD-MASTERS

Merlin Home

Please select one of the following options, or click HERE for more help

Welcome Philip Siu

Action	Description
Configure a System	Allows you to select components for a new system or to load an existing system from your list of saved systems.
View Catalog	In this section you can search and view all Mold-Masters catalog pages.
Order Spare Parts	This is an order entry system which allows you to order extra parts for your existing systems.
Order Inquiry	This section lists the orders that you have made, whether current or historical. It also lists the status of orders.

Done Start Stop Back Forward Stop Refresh Home Search Favorites History Mail Print Edit

2:20 PM

F16.4

3 120 -

Mold-Masters Online Design Guide - Microsoft Internet Explorer

File Edit View Favorites Tools Help

Back Forward Stop Refresh Home Search Favorites History Mail Print Edit

Address http://172.16.3.2:2525/default.htm

Search Guest Toolbar Sign in My Yahoo News Entertainment Sports Shopping More

MERLIN Configuration MOLD-MASTERS

Merlin Home Merlin Support

Configuration

Please make a selection. For detailed information concerning your possible choices click [here](#).

Action	Description
Configure New System	Allows you to configure a new system and save it to your account.
Existing Configurations	Allows you to load an existing system from a list of saved systems.

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Internet Explorer 221 PM

Start

Fig. 5

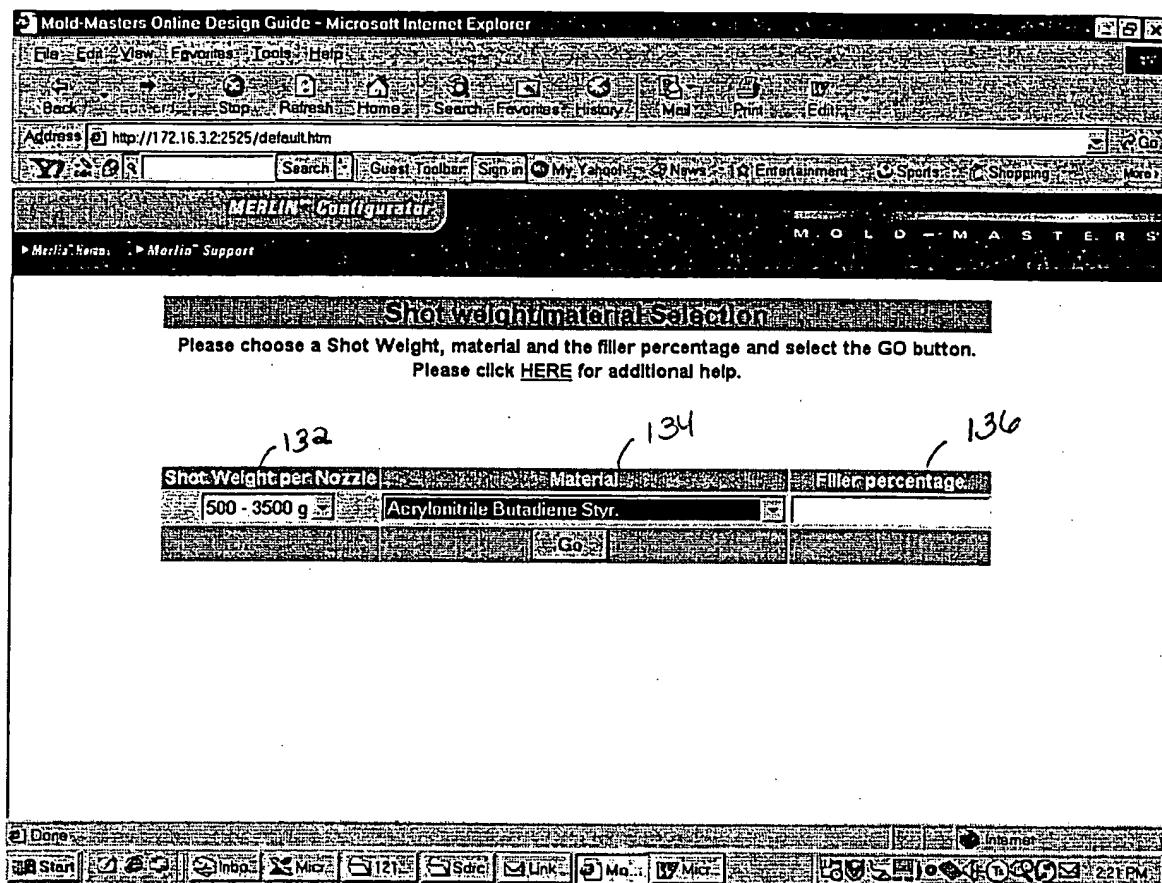


FIG. 6.

MERLIN® Configurator

[Merlin Home](#) [Merlin Support](#)

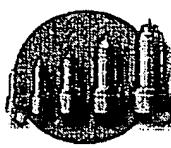
MOLDING MASTERS

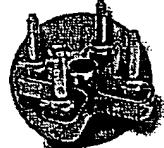
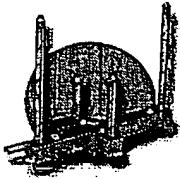
Product Line Selection

Please select a product line by clicking on the button below it. Click [here](#) to find out more information.

[Previous Step](#)

140



[Dura™](#) 142

[MIM Dura-Shot®](#) 144

[MIM Speed™](#) 146

[Flex Dura™ System](#) 147

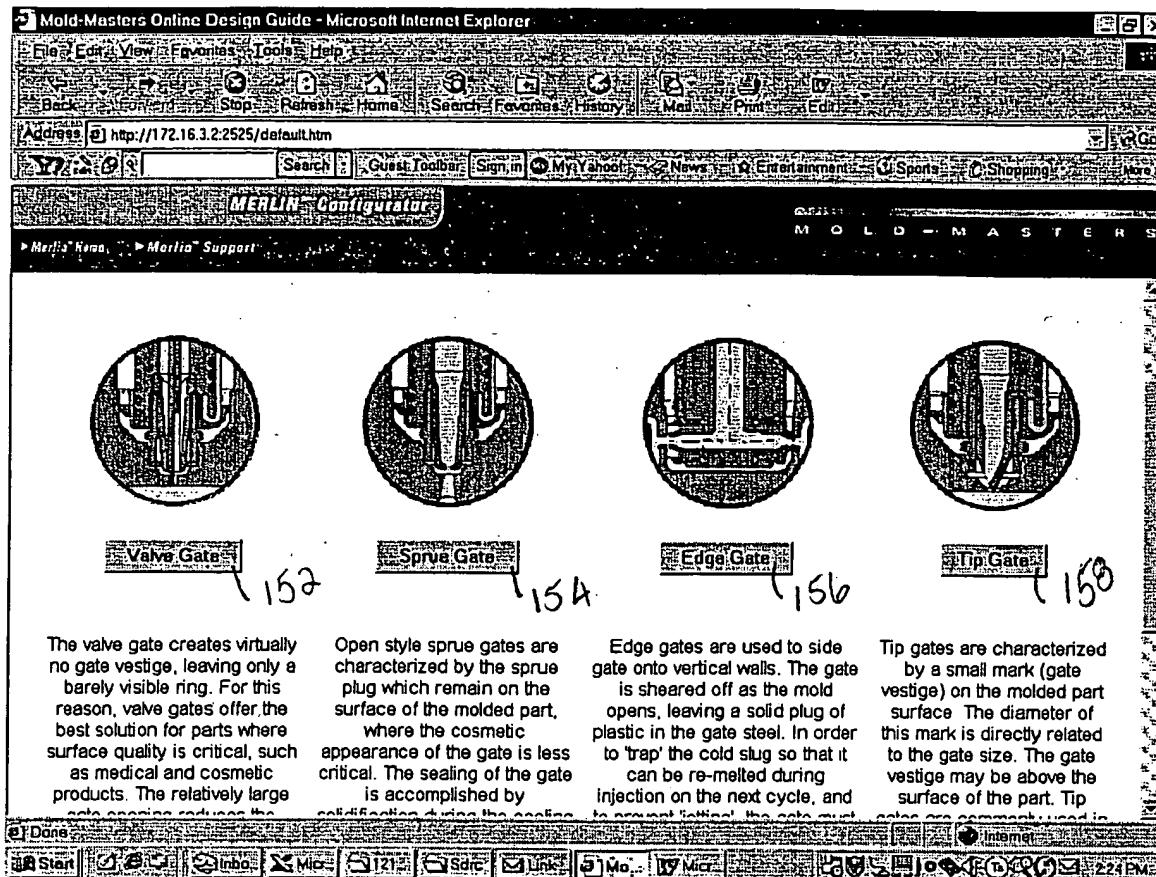
Mold Masters established Dura product line of hot runner systems.

The MIM Dura-Shot® range of products is based on Mold-Masters established Dura know-how, but with the added advantages of MIM technology.

Specify, Design and Order your MIM Speed Hot Runner System - Online to provide the fastest delivery of the hot runner system to your specification.

The Flex Dura product line was developed specifically for the automotive and large part molding industries.

3 150



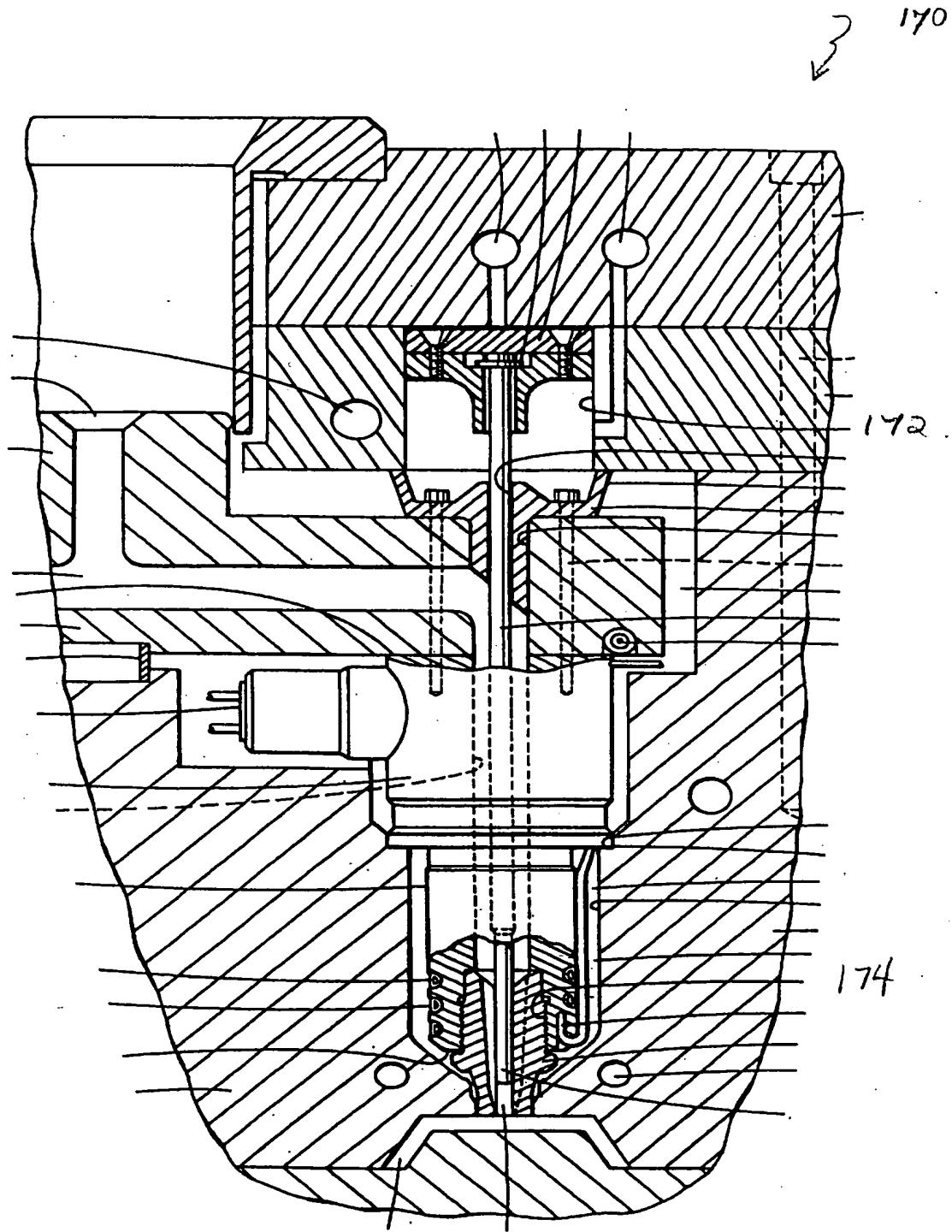
The valve gate creates virtually no gate vestige, leaving only a barely visible ring. For this reason, valve gates offer the best solution for parts where surface quality is critical, such as medical and cosmetic products. The relatively large gate opening reduces the

Open style sprue gates are characterized by the sprue plug which remain on the surface of the molded part, where the cosmetic appearance of the gate is less critical. The sealing of the gate is accomplished by

Edge gates are used to side gate onto vertical walls. The gate is sheared off as the mold opens, leaving a solid plug of plastic in the gate steel. In order to 'trap' the cold slug so that it can be re-melted during injection on the next cycle, and to prevent lifting the gate, the gate must

Tip gates are characterized by a small mark (gate vestige) on the molded part surface. The diameter of this mark is directly related to the gate size. The gate vestige may be above the surface of the part. Tip gates are commonly used in

FIG. 8



F16.9

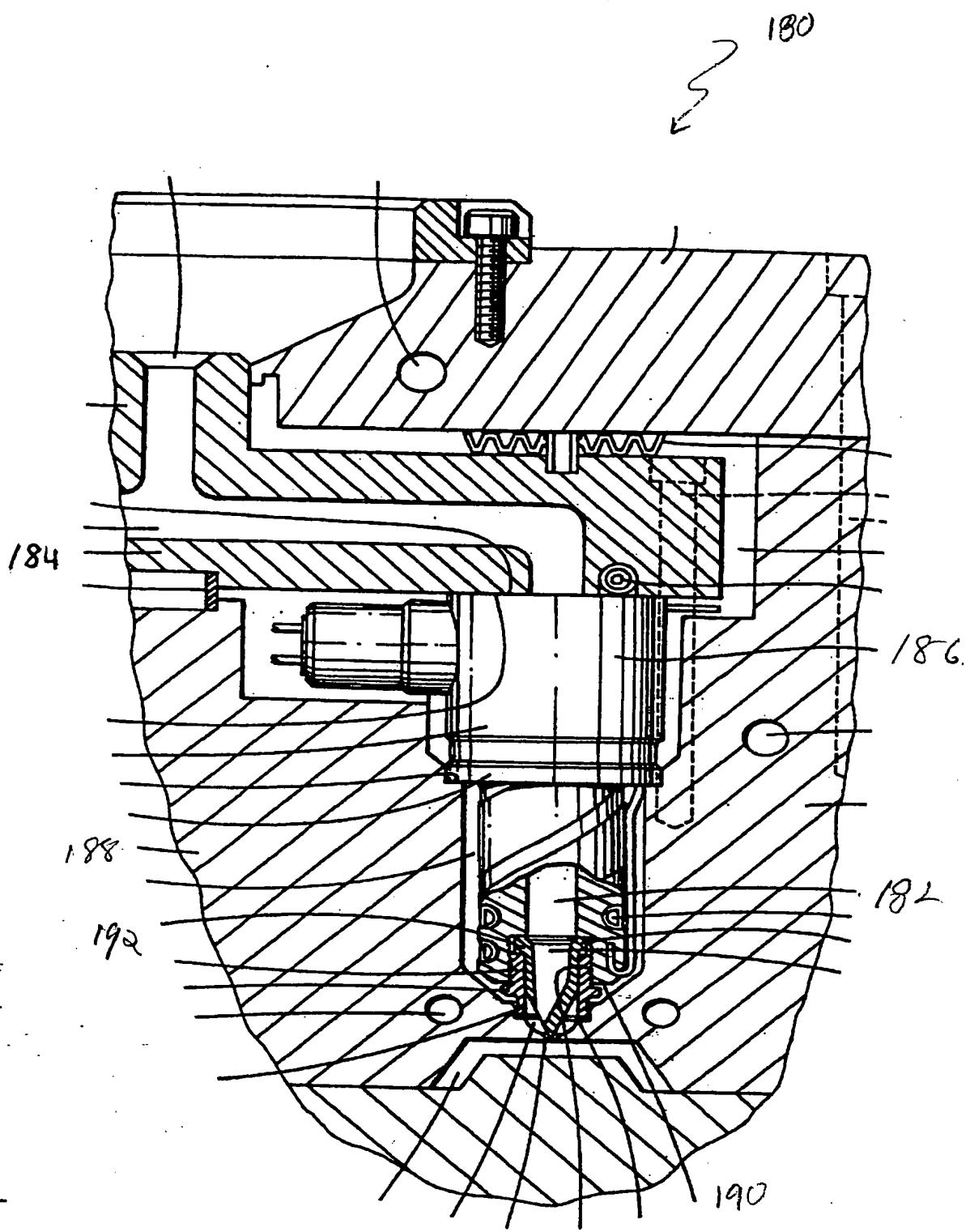


FIG. 10

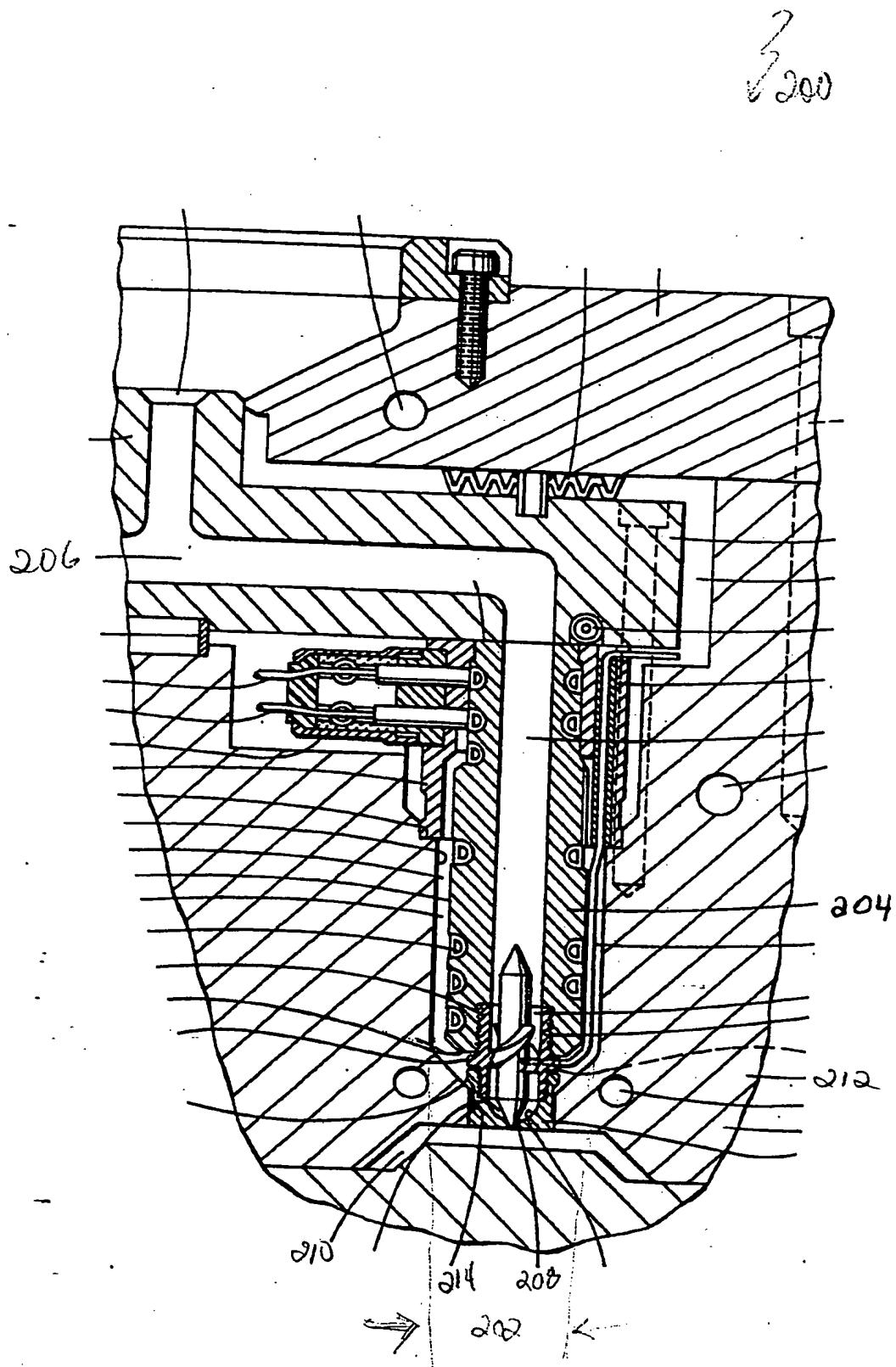


FIG. 11

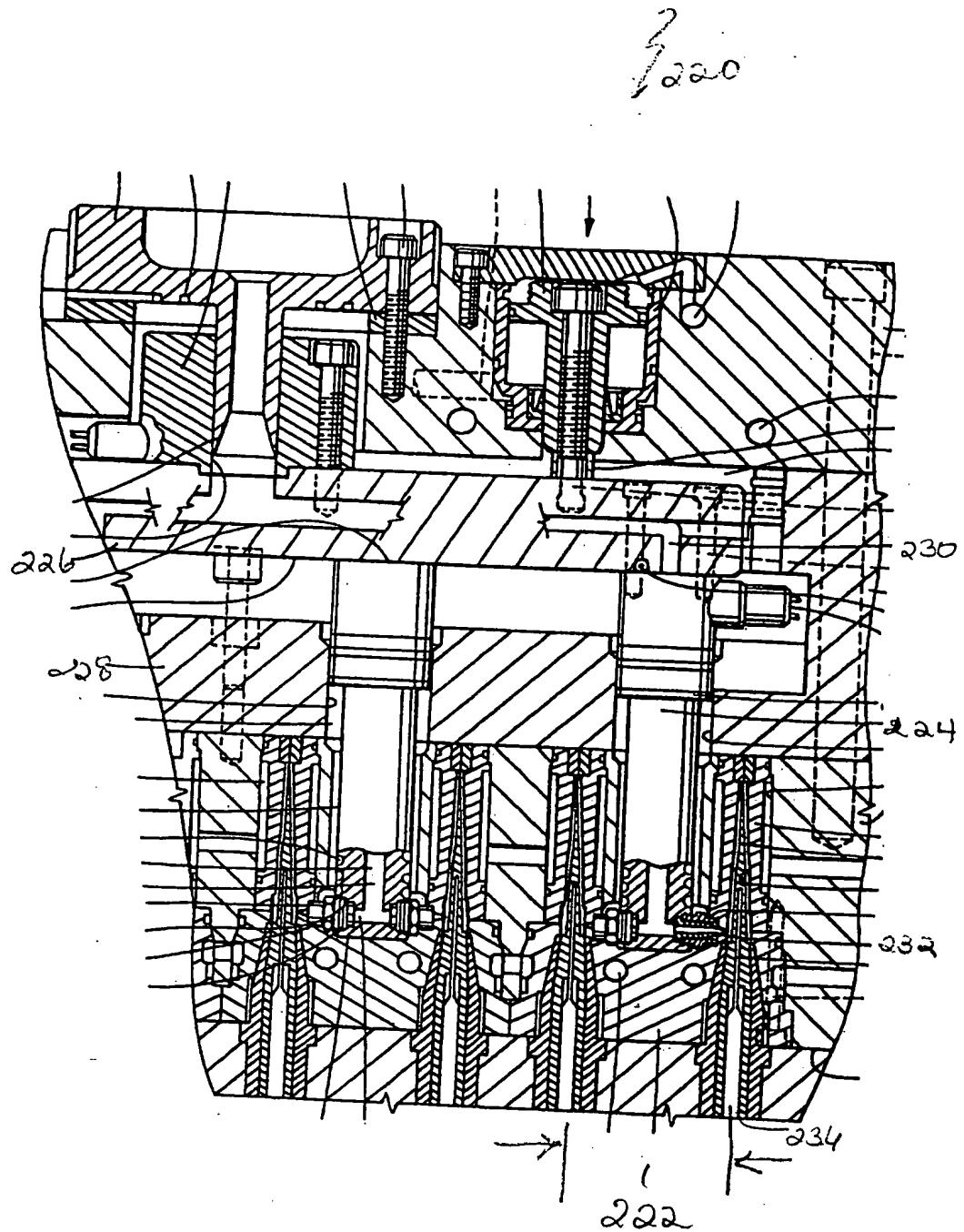


FIG. 12

5240

MERLIN® Configurator

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M I M S Y S T E M S

System type/Gating method Selection

Click on the number beside the system type to continue. Click on one of the links below to find out more information about the item

Click [Here](#) for more information.

[Previous Step](#)

Match System Type	Gating Method	Suitability	Catalog Page/s
<input checked="" type="checkbox"/> MIM Speed Dura Hecto-Shot 242	Bi-Metallic C-Valve 244	Recommended 246	View M8.01.05 248

260
3

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Merlin Home ▶ Merlin Support

M F O L D - M A S T E R E X P R E S S

MIM Dura Hecto-Shot® Bi-Metallic C-Valve

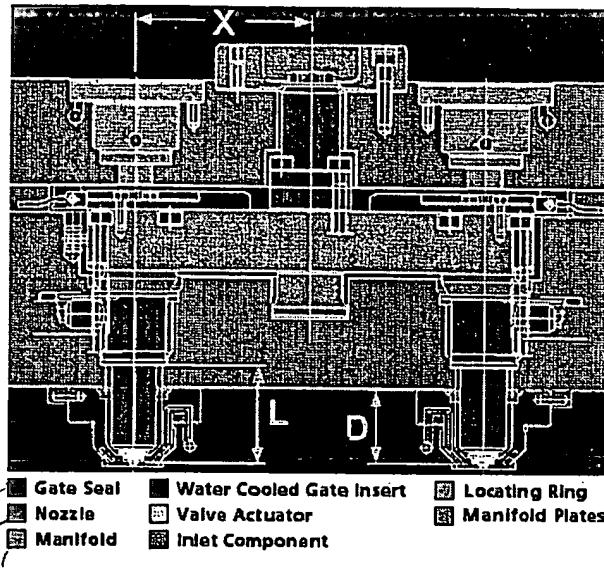
Gate Seal

Please select the gate seal you require, or click [HERE](#) for more information.

[Previous Step](#)

Part Number	Description	Diameter/Range
<input checked="" type="checkbox"/> TS0664P2	MDH C VALVE	4.0 - 5.0 mm
	TS0664 + TSL229	

268



262
264
266

Relevant Catalog Pages

Catalog Page Title

[View](#) M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

270

Revision Date CAD Drawings
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12:41AM

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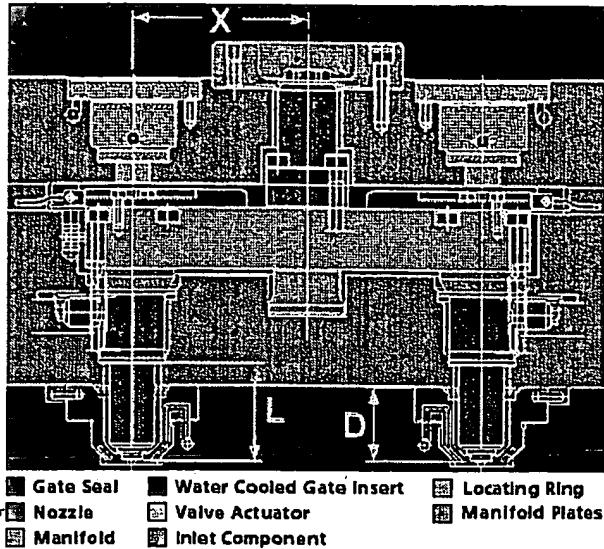
3280

Nozzle

Please select the nozzle you require, or click [HERE](#) for more information.

[Previous Step](#)

Part No.	March Nozzle #	Description	L Dim (mm)
282	1	NZMH1B1A060P Mim Dura Hecto Valve nozzle L=60	74
284	2	NZMH1B1A090P Mim Dura Hecto Valve nozzle L=90	104
286	3	NZMH1B1A120P Mim Dura Hecto Valve nozzle L=120	134
288	4	NZMH1B1A150P Mim Dura Hecto Valve nozzle L=150	164

MIM Dura Hecto-Shot® Bi-Metallic C-Valve**Relevant Catalog Pages****Catalog Page** **Title**

[View](#) M8.01.05 MDH C VALVE TS0664 + TSL229

[View](#) M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

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MINOLTA MIM DURA SHOT BURRS

Number Of Nozzles Selection

Please select the number of nozzles required for your system, or Click HERE for more information

[Previous Step](#)

Enter Number of Nozzles/Drops desired in System

302 2 Nozzles

304 4 Nozzles

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

306 308

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MOLD - MASTERS

Manifold Configuration Selection

Please choose a suitable manifold configuration from the icons shown below or click [HERE](#) for more detailed information.

[Previous Step](#)

Standard Sub Manifolds



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Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot ® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

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3 340

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M O D E L M A S T E R S

Sub Manifold Pitch Selection

Click Here for more detailed information

Previous Step

Click the Next button to accept this dimension or enter a smaller pitch dimension for your application if required.

Off Pitch X: 190 mm

Next

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Relevant Catalog Pages

Catalog Page Title

M8.01.05 Mim Dura Hecto Valve nozzle L=120

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CAD Drawings

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M8.01.05 MDH C VALVE TS0664 + TSL229

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12:41AM

M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

Jun 6 2000
12:41AM

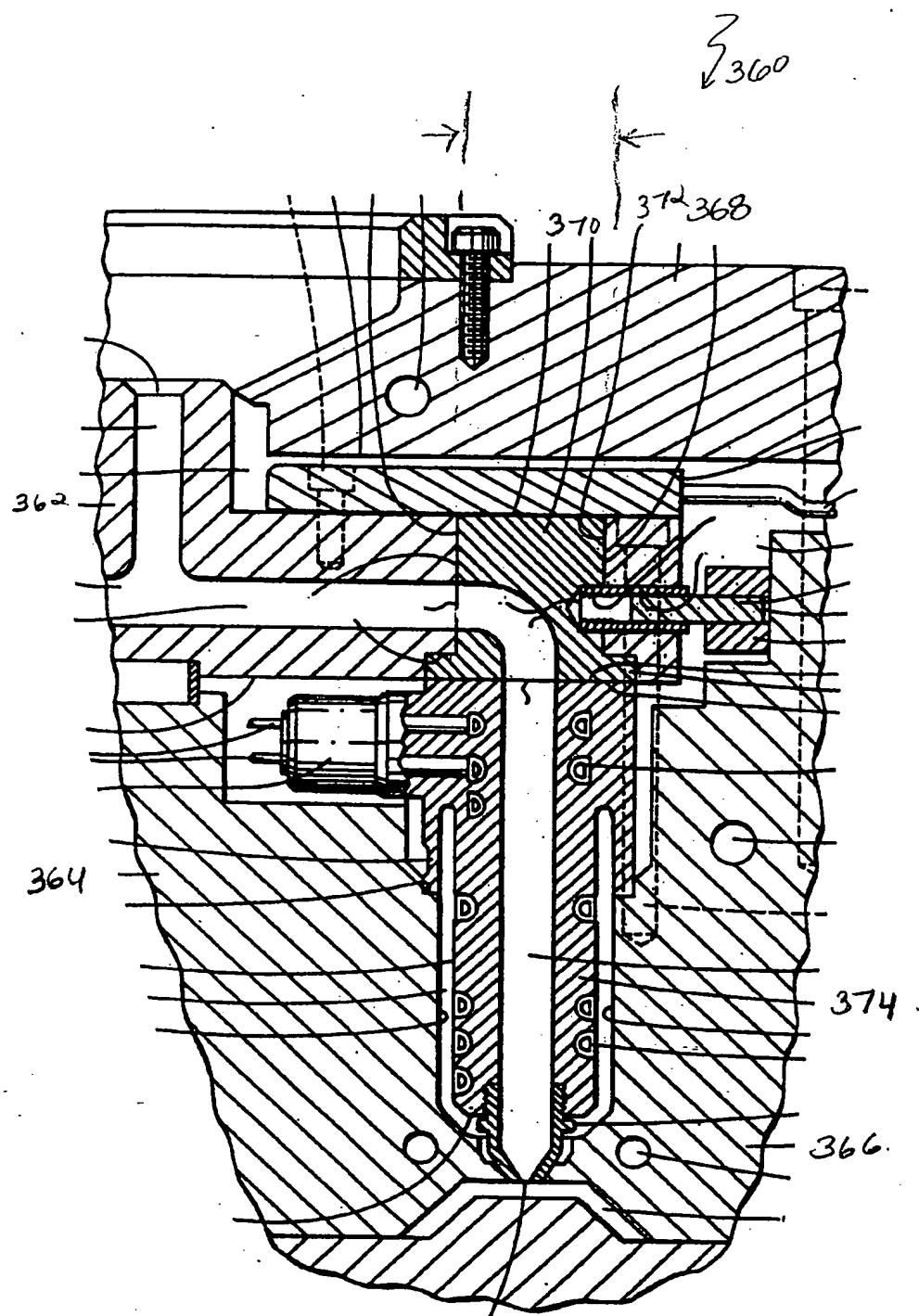


FIG. 19

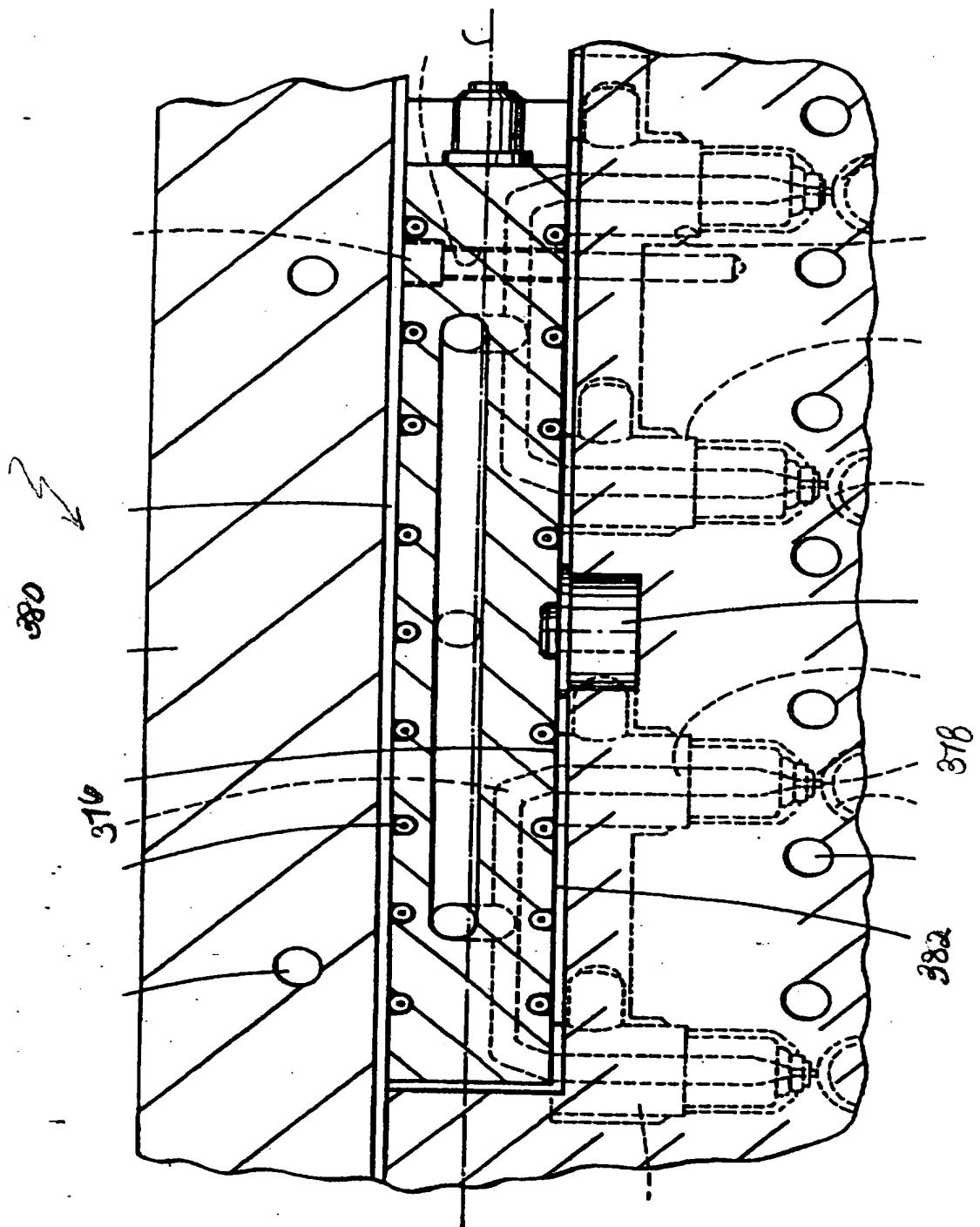
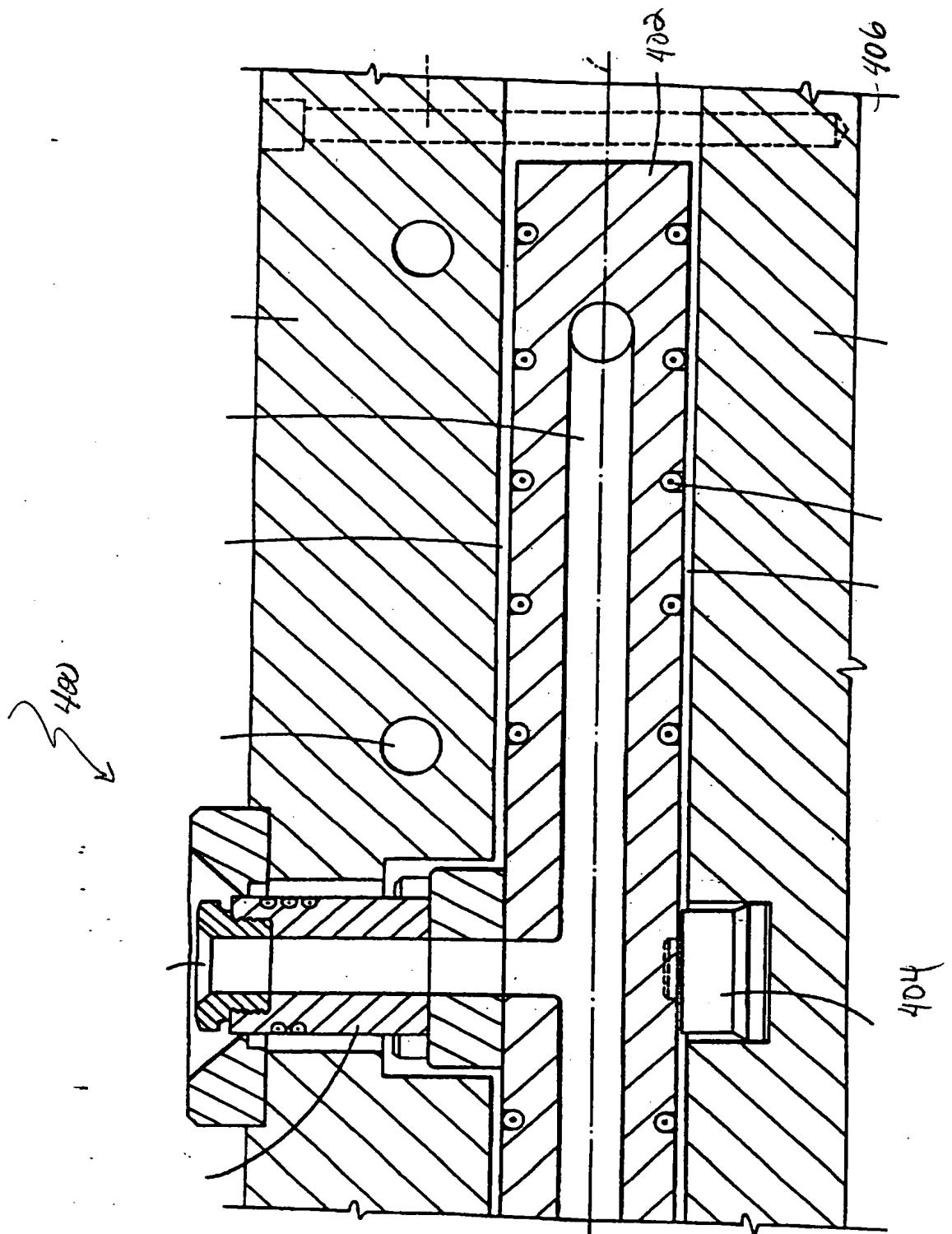


FIG. 20



الملحق

3 420

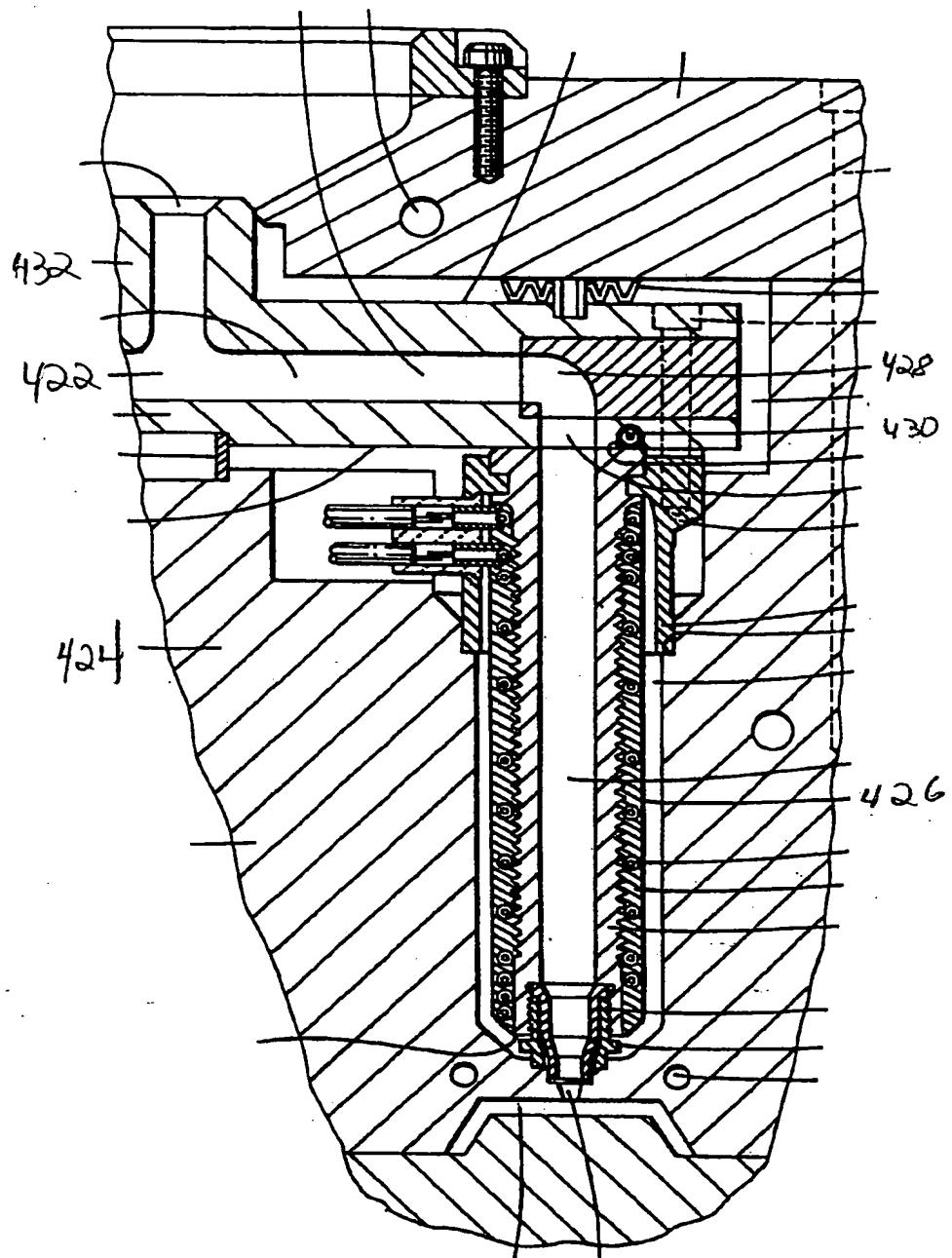


FIG. 22

2440

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M O L D - M A S T E R S

Water Cooled Gate Insert (Optional)

Please select the gate insert you require, or click [HERE](#) for more information.

[Previous Step](#)

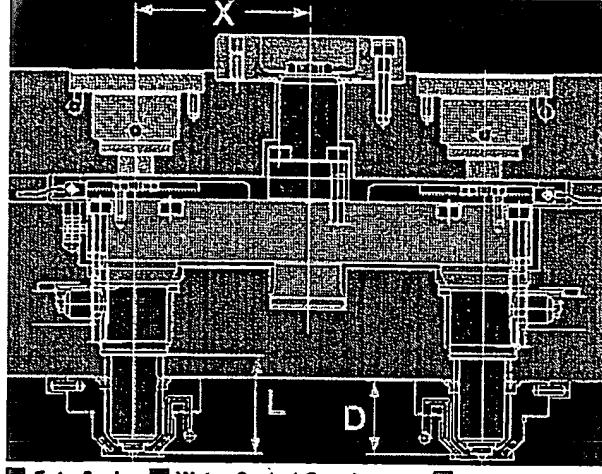
Match Gate Insert# Description

O-Dimension

Water Cooled Gate Inserts are not available for this application.

[NEXT](#)

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



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Relevant Catalog Pages

Catalog Page Title

[View](#) M8.02.02 2-Inline Sub Manifold

Revision Date

Jun

CAD Drawings

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[View](#) M8.01.05 Mim Dura Hecto Valve nozzle L=120

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[View](#) M8.01.05 MDH C VALVE TS0664 + TSL229

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[View](#) M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

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12:41AM

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FIG. 23

3 460

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Micro-Load Materials Transfer Systems

Valve Actuator

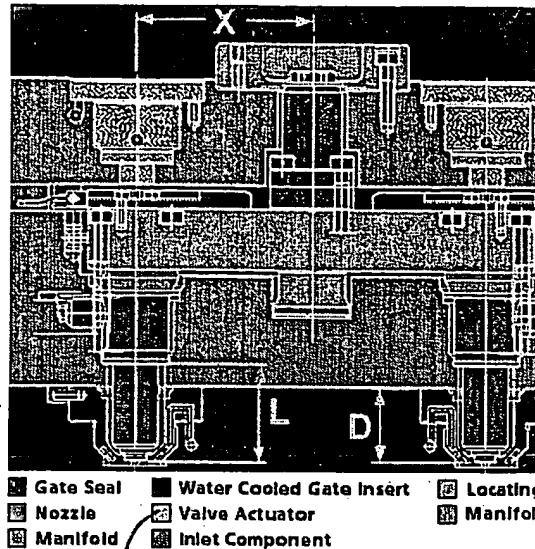
Please select the valve actuator you require, or click [HERE](#) for more information.

[Previous Step](#)

Match Actuator #	Valve Description	Valve Pin Max. Diameter	Valve Pin Stroke Length
<input checked="" type="checkbox"/> HY6600D	Hydraulic/Pneumatic Cylinder Assembly	355.0 mm	7.940 mm

464

MIM Dura Hecto-Shot® Bi-Metallic C-V



462

Relevant Catalog Pages

Catalog Page Title

- [View](#) M8.02.02 2-Inline Sub Manifold
- [View](#) M8.01.05 Mim Dura Hecto Valve nozzle L=120
- [View](#) M8.01.05 MDH C VALVE TS0664 + TSL229
- [View](#) M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

Revision Date

- Jun 6 2000 12:41AM

CAD Drawings

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- [Download](#)
- [Download](#)
- [Download](#)

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FIG. 24

3480

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MANUFACTURING STATEMENTS

Inlet Component

Please select the Inlet Component you require, or click [HERE](#) for more information.

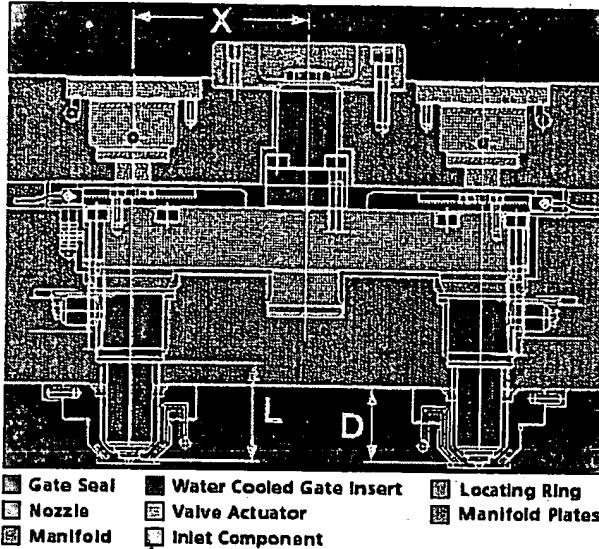
[Previous Step](#)

Matches Description

 Manifold center heater

484

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



Relevant Catalog Pages

Catalog Page Title

486

Catalog Page	Title
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly
View	M8.02.02 2-Inline Sub Manifold
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120
View	M8.01.05 MDH C VALVE TS0664 + TSL229
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

Revision Date

98-Oct-22

CAD Drawings

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MOLDMASTER

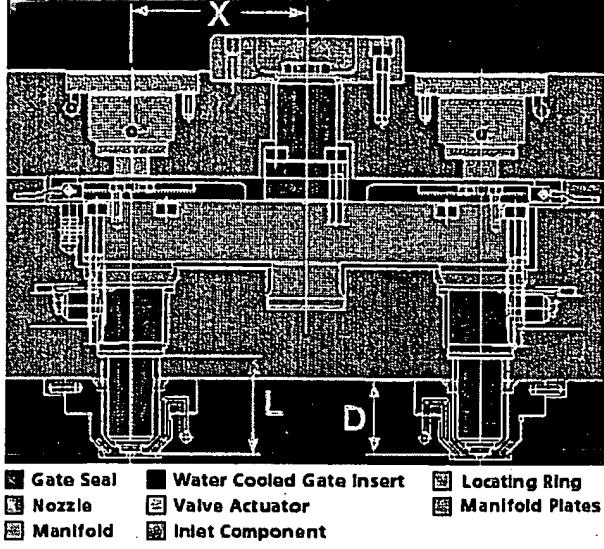
Inlet Component Manifold center heater
Please select the Inlet Component you require, or click [HERE](#) for more information.

[Previous Step](#)

Matches Inlet Component# Machine Nozzle Radius
BP58.500P 0.5 inch
BP58.750P 0.75 inch

502

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



504

Relevant Catalog Pages

Catalog Page	Title	Revision Date	CAD Drawings
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly	98-Oct-22	Download 506
View	M8.02.02 2-Inline Sub Manifold	Jun.	Download
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120	Jun 6 2000 12:41AM	Download
View	M8.01.05 MDH C VALVE TS0664 + TSL229	Jun 6 2000 12:41AM	Download
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve	Jun 6 2000 12:41AM	Download

F16.26

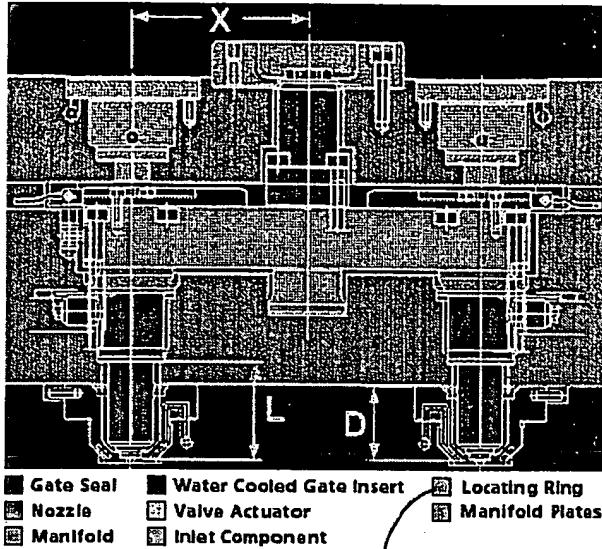
Location Ring

Please select the locating ring you require, or click [HERE](#) for more information.

[Previous Step](#)

Matches Locating Ring #	Description	Diameter (mm)
1	LR0070 Loc. ring for machine nozzle pad	101.34
2	LR0071 Loc. ring for machine nozzle pad	109.75
3	LR0081 Locating Ring for Valve system with BP58, inch	101.36
4	LR0082 Locating Ring for Valve system with BP58, metric	109.77
5	LR0086 Locating Ring for Sprue system with BP58, inch	101.36
6	LR0087 Locating Ring for Sprue system with BP58, metric	109.77

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



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Relevant Catalog Pages

Catalog Page Title

View	10.01.11 Manifold center heater
View	12.01.12 Hydraulic/Pneumatic Cylinder Assembly
View	M8.02.02 2-Inline Sub Manifold
View	M8.01.05 Mim Dura Hecto Valve nozzle L=120
View	M8.01.05 MDH C VALVE TS0664 + TSL229
View	M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

Revision Date CAD Drawings

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MANUFACTURING MATERIALS & PARTS

Molding Elevation

If you wish to include a Molding Elevation, please enter it below and choose the Unit of Measure.

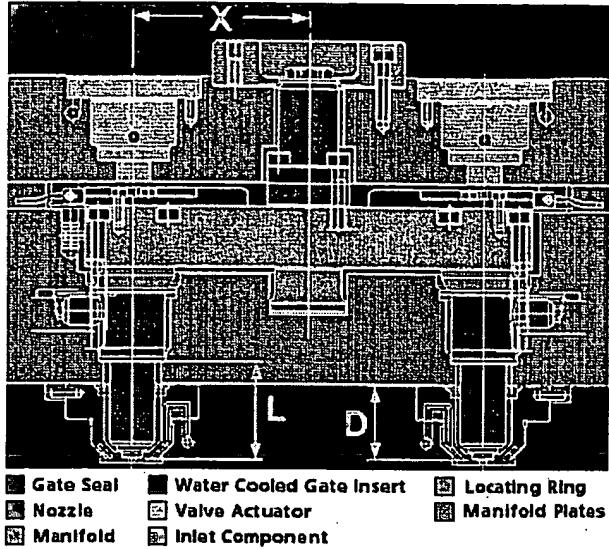
Click [HERE](#) for more information.

[Previous Step](#)

There is no Molding Elevation range available for this application. Click [Next](#) to continue or try another application.

[Next](#)

MIM Dura Hecto-Shot® Bi-Metallic C-Valve



Relevant Catalog Pages

Catalog Page Title

[View](#) M9.01.08 Locating Ring for Valve system with BP58, inch

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[View](#) 10.01.11 Manifold center heater

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[View](#) 12.01.12 Hydraulic/Pneumatic Cylinder Assembly

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[View](#) M8.02.02 2-Inline Sub Manifold

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[View](#) M8.01.05 Mim Dura Hecto Valve nozzle L=120

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[View](#) M8.01.05 MDH C VALVE TS0664 + TSL229

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[View](#) M8.01.05 MIM Dura Hecto-Shot® Bi-Metallic C-Valve

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MERLIN Configurator

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MY TOOL ORDER STATUS REQUEST

Application Information Form

Please fill in the relevant information and check for correctness.

[Previous Step](#)

Action To Be Taken, For more information click [HERE](#)

Company Name:

Contact Name:

Mold Maker:

Molder:

End User:

Customer Ref. #:

Requested Delivery Date: (in MM/DD/YYYY format)

Plastic Part #	Plastic Part Name	Industry Segment
<input type="text"/>	<input type="text"/>	<input type="text"/>

Additional Information

Material	Part	Mold	Other
<u>Material type :</u> Acrylonitrile Butadiene Styr.	<u>Shot Weight :</u> 500 - 3500 g	<u># of Cavities</u> <input type="text"/> 564	<u>Gate Cosmetics</u> <input type="text"/>
<u>Grade</u> <input type="text"/>	<u>Est. Injection Time (sec.)</u> <input type="text"/>	<u>Sub-runners</u> <input type="text"/>	<u>Gate Cooling</u> <input type="text"/> 560
<u>Supplier</u> <input type="text"/>	<u>Wall Thickness</u> <input type="text"/> mm <input type="button" value="▼"/>	<u>Gate</u> <input type="text"/> mm <input type="button" value="▼"/>	<u>Dim. Stability</u> <input type="text"/>
<u>Process Temp</u> <input type="text"/> C	<u>Flow Length</u> <input type="text"/> mm <input type="button" value="▼"/>	<u>Land</u> <input type="text"/> mm <input type="button" value="▼"/>	<u>Supp. Screws</u> <input type="text"/>

Summary Information Form

Please fill in the relevant information and check for correctness.

Previous Step

View/Printable Version

Action To Be Taken, For more information click [HERE](#)

Step 1

Save

580

Step 2

Quote

584

Step 3

Review

586

Step 4

Order

588

Lead Time: No Lead Time Available.

Quote #: 0040003107

Order #:

Generate Drawings

Price: \$6,081.00 USD

PO#

Company Name:

590

Contact Name:

N/A

Mold Maker:

Molder:

End User:

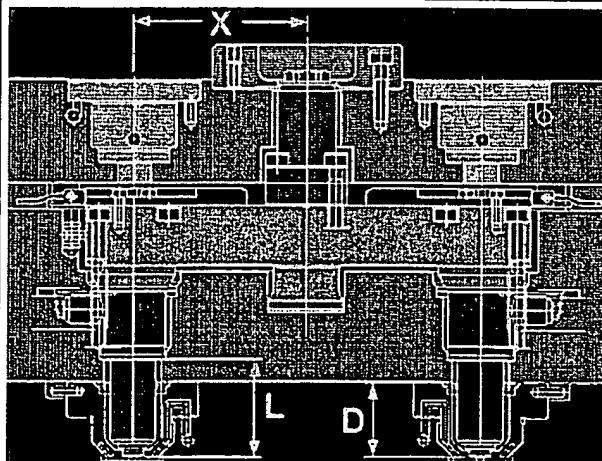
Customer Ref. # :

Requested Delivery Date:

Plastic Part #:

Plastic Part Name:

Industry Segment:



Required Parts List		
Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH2I200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material

Part

Mold

Other

Material type:
Acrylonitrile Butadiene
Styr.Sh. t Weight: 500 -
3500 g

of Cavities:

Gate Cosmetics:

Grade:

Est. Injection Time
(sec.):

Sub-runners:

Gate Cooling:

Supplier:

Wall Thickness:

Gate:

Dim. Stability:

3600

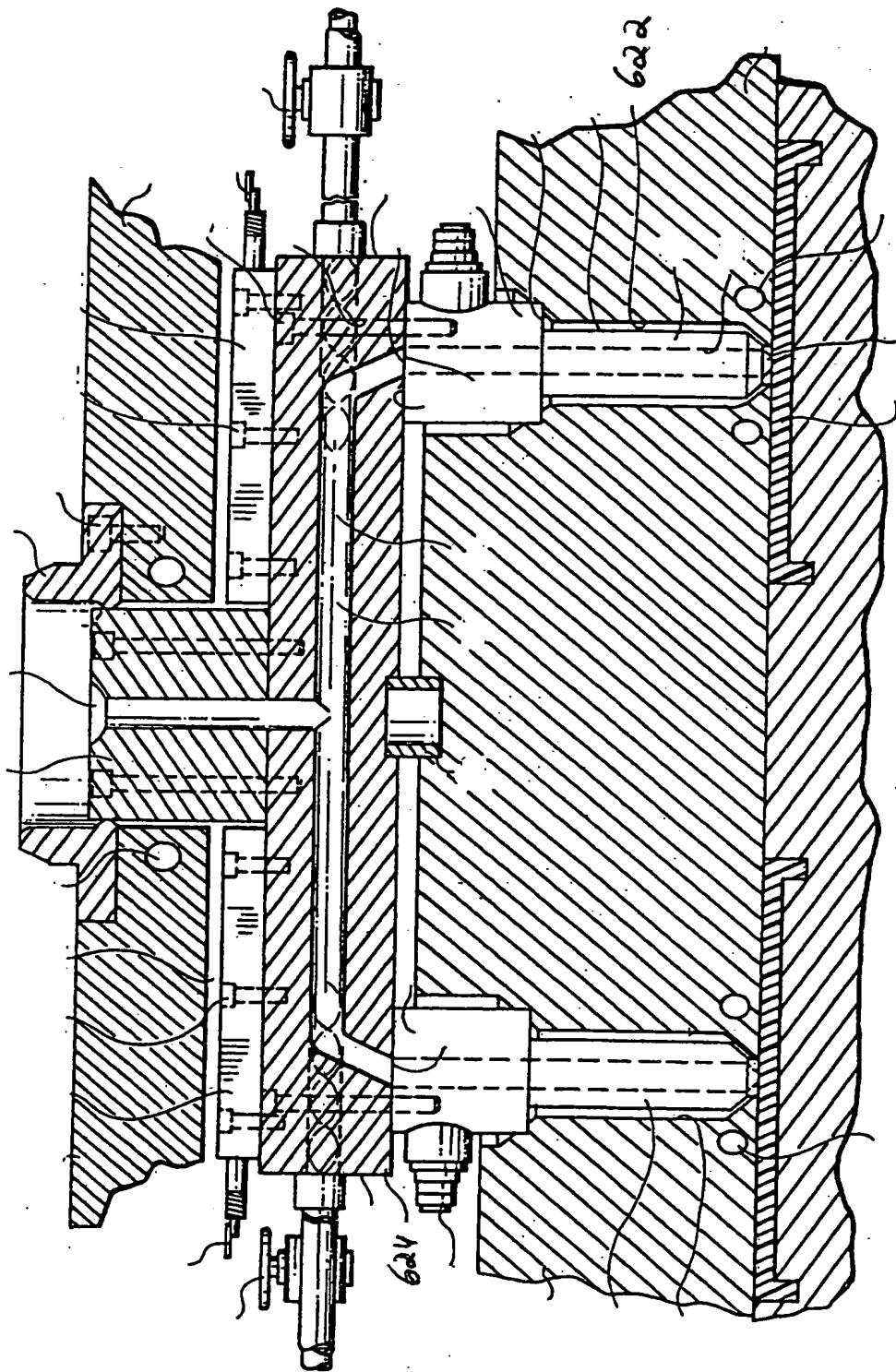
Generated Drawings

Choose any of the file options below to download or view online

Type	Drawings	Options
TIF	<u>GT_sys_valve_config_HY6600_0077.tif</u> (1449539 Bytes)	Download 602 View 604
TIF	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.tif</u> (1170968 Bytes)	Download View
DXF	<u>GT_sys_valve_config_HY6600_0077.dxf</u> (1095118 Bytes)	Download View
DXF	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.dxf</u> (1786603 Bytes)	Download View
IGS	<u>GT_sys_valve_config_HY6600_0077.igs</u> (2487962 Bytes)	Download View
IGS	<u>GT_sys_valve_config_SYSTEM_ASSEMBLY.igs</u> (2302724 Bytes)	Download View
WRL	<u>GeneralAssembly.wrl</u> (2461551 Bytes)	Download View

FIG. 31

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MOLD-MASTERS®

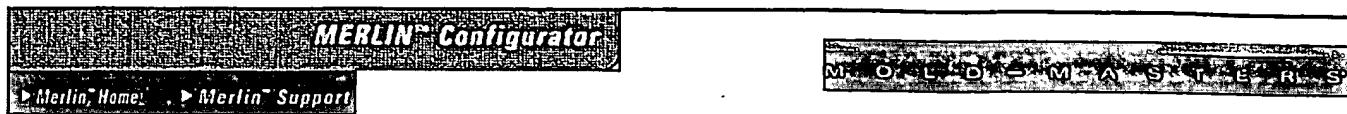
Configurator

Please make a selection. For detailed information concerning your possible choices click [here](#).

Action	Description
Configure New System	Allows you to configure a new system and save it to your account.
Existing Configurations	Allows you to load an existing system from a list of saved systems.

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3 660



Existing Configurations

Please Make a selection. For detailed information concerning your possible choices click HERE

Action	Configuration Name	Quote #	Order #	Date/Time	Status
<input type="button" value="Load"/> <input type="button" value="Copy"/> <input type="button" value="Delete"/>	Previous Config 662	0040003107		6/12/00 2:39:47 PM	
<input type="button" value="Load"/> <input type="button" value="Copy"/> <input type="button" value="Delete"/>	SAP Test	0040003098		6/9/00 11:31:20 AM	
<input type="button" value="Load"/> <input type="button" value="Copy"/> <input type="button" value="Delete"/>	2 drop hect 190 pitch	0040003093		6/8/00 1:53:36 PM	

Summary Information Form

Please fill in the relevant information and check for correctness.

Action To Be Taken, For more information click [HERE](#)

Step 1

682

Step 2

684

Step 3

686

Step 4

688

Lead Time: No Lead Time Available.

Quote #: 0040003107

Order #:

Price: \$6,681.00 USD

PO #

N/A

Company Name:

10

Contact Name:

Mold Maker:

Molder:

End User:

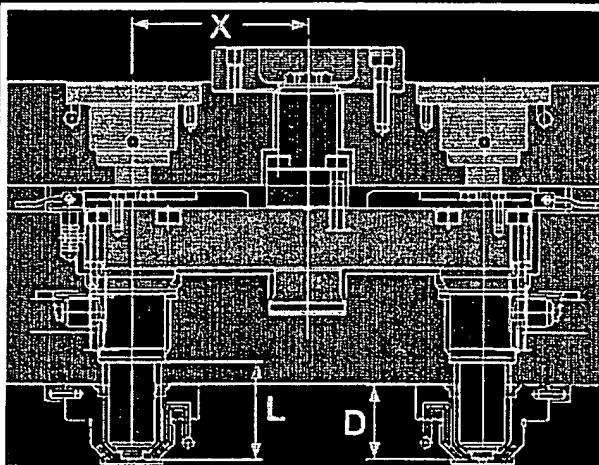
Customer Ref. # :

Requested Delivery Date:

Plastic Part # :

Plastic Part Name:

Industry Segment :



Required Parts List		
Part Number	Description	Options
TS0664P2	MDH C VALVE TS0664 + TSL229	N/A
NZMH1B1A120P	Mim Dura Hecto Valve nozzle L=120	N/A
MNMDH2I200BL4VP	2-Inline Sub Manifold	N/A
HY6600D	Hydraulic/Pneumatic Cylinder Assembly	N/A
BP58.750P	Manifold center heater	N/A
LR0081	Locating Ring for Valve system with BP58, inch	N/A

Additional Information

Material

Part

Mold

Other

Material type:

Acrylonitrile Butadiene
Styr.

Shot Weight : 500 -
3500 g

of Cavities :

Gate Cosmetics:

Grade:

Est. Injecti n Time
(sec.):

Sub-runners:

Gate Cooling:

Supplier:

Wall Thickness:

Gate:

Dim. Stability: